

Shy April 24

Work Order ID 82768

82768

April-09-12 10:10:07 AM

Item ID: D4092-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step Assembly

Start Date: 4/09/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/19/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4092	B
-------	---

100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

12x Ø

EF 12/6/20

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in-lbs

12x Ø

EF 12/6/20

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8.26/20

12x Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82768

82768

Page 2

April-09-12 10:10:07 AM

Item ID: D4092-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step Assembly

Start Date: 4/09/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/19/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *PPP*

0.00

130

Packaging

Memo

82763

0.00

Packaging

12/4/20 (12)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/20

MF

12-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-09-12 10:10:06 AM

Page 1

Work Order ID: 82768

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4092-1		Manufactured	No			100	Each	4.0000	2	24		4/12/04/20	
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	------------	--

Maintenance Step

Location	Loc Qty	Loc Code
GA	3	
77852	1	
80564	2	
ST241A	1	
74303	1	

D4093-1		Manufactured	No			100	Each	7.0000	1	12		4/12/04/20	
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	------------	--

Bracket

Location	Loc Qty	Loc Code
ST195	7	
78911	7	

D4093-3		Manufactured	No			100	Each	21.0000	1	12		4/12/04/20	
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	------------	--

Bracket

Location	Loc Qty	Loc Code
ST195	21	
77850	1	
80084	20	

D4093-5		Manufactured	No			100	Each	14.0000	2	24		4/12/04/20	
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	------------	--

Bracket

Location	Loc Qty	Loc Code
ST124	14	
80085	2	
80226	12	

B82765
(200)

B82766
(50)

B82764
(120)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-09-12 10:10:07 AM

Page 2

Work Order ID: 82768

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00

Required Qty: 12.00

MS24694-S54

Purchased

No

100

Each

124.0000

2

24

Screw

Location

Loc Qty

Loc Code

ST289A

124

120142

4

120361

20

121166

100

MS24694-S55

Purchased

No

100

Each

183.0000

8

96

Screw

Location

Loc Qty

Loc Code

ST289A

183

119307

33

120833

50

120910

100

MS24694-S56

Purchased

No

100

Each

59.0000

2

24

SCREW

Location

Loc Qty

Loc Code

ST289A

59

120142

34

120833

25

NAS1149D0332J

Purchased

No

100

Each

3,309.0000

12

144

Washer

Location

Loc Qty

Loc Code

ST298

3309

105793

12

110985

4

117087

89

119042

38

119717

620

120644

546

121011

2000

April-09-12 10:10:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-09-12 10:10:07 AM

Page 3

Work Order ID: 82768

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00

Required Qty: 12.00

MS21042L3

Purchased

No

100

Each

2,274.0000

12

144

Nut

Location

Loc Qty

Loc Code

ST300

2274

117441

16

117885

32

118451

5

118927

3

119017

2030

119075

166

121162

22

139

M121349
52

April-09-12 10:10:07 AM

Shop Packet Print

Page 3

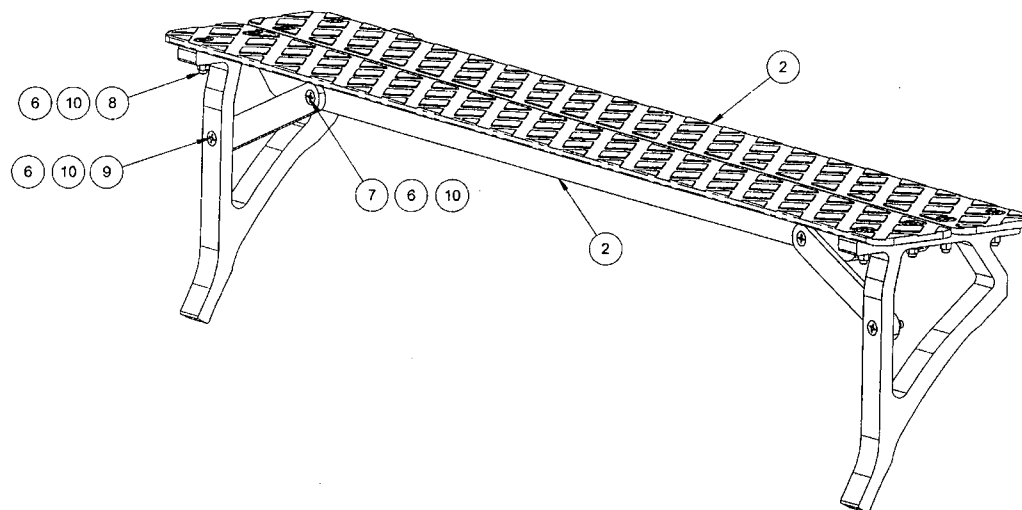
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4092-041 MAINTENANCE STEP ASSEMBLY

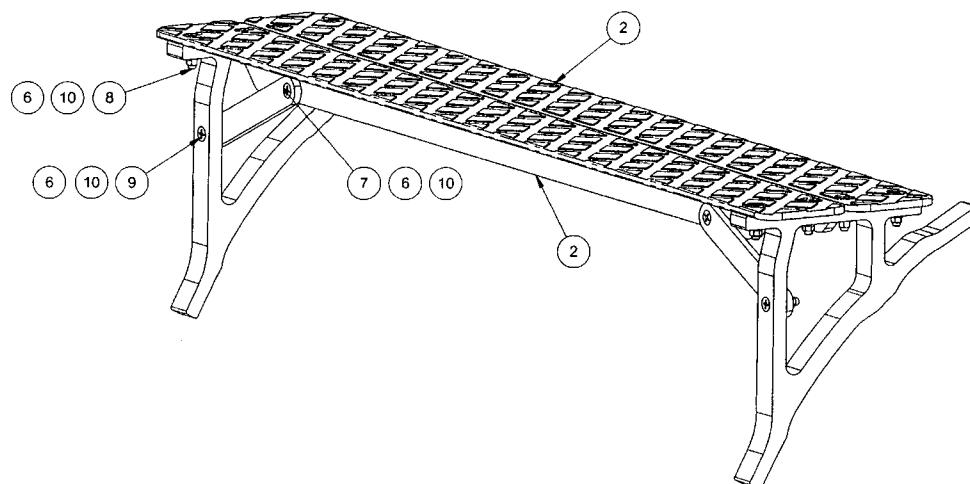


ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22
ANN

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 1 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

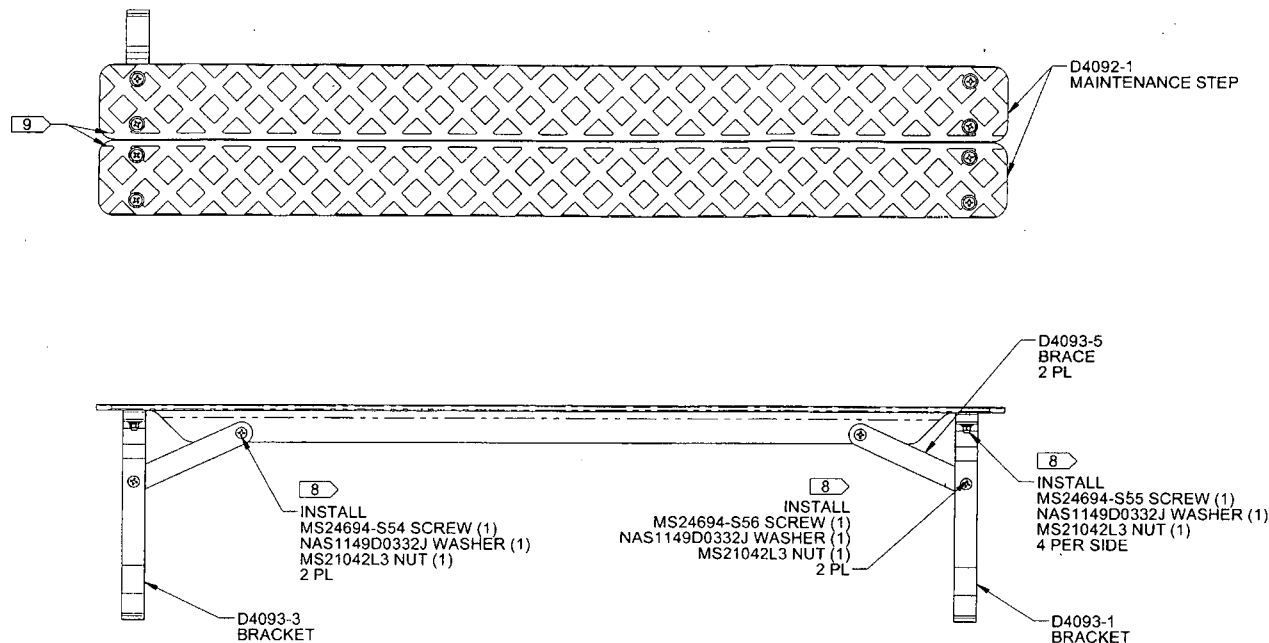


D4092-042 MAINTENANCE STEP ASSEMBLY



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2011-09-22
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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
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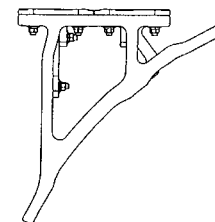
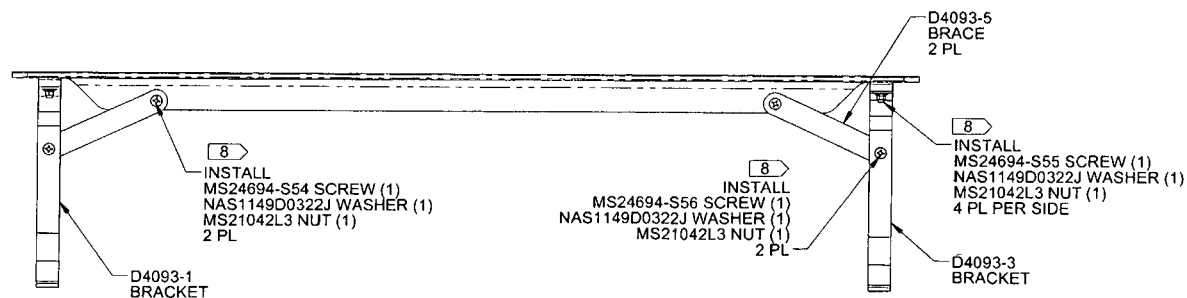
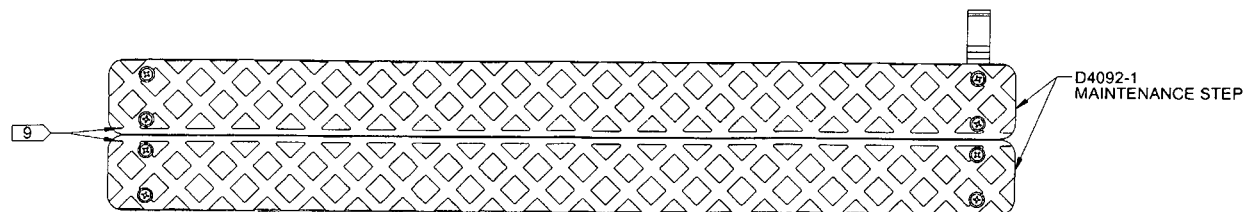
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 3 OF 6
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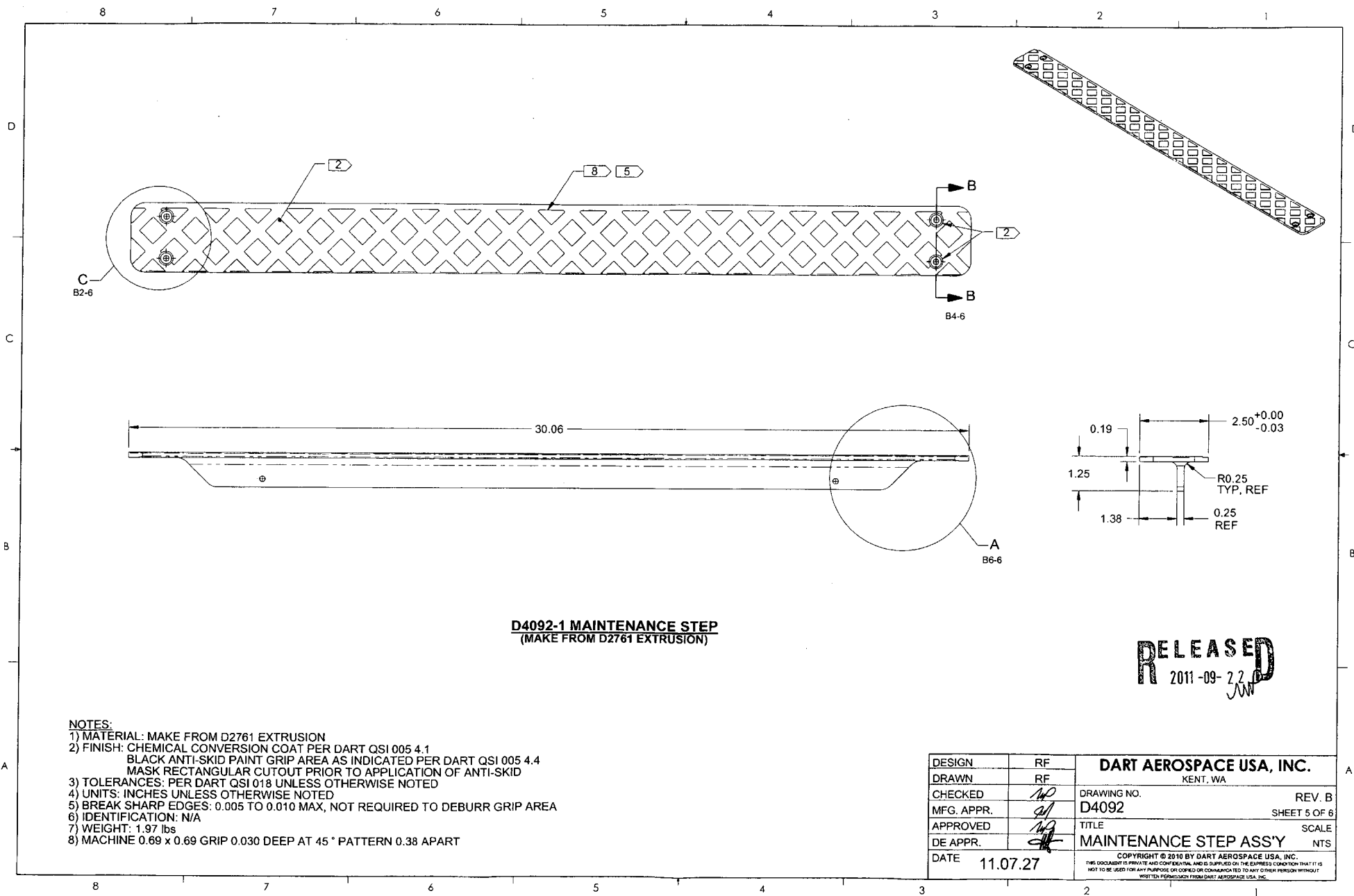


RELEASED
2011-09-22
JWC

D4092-042 MAINTENANCE STEP ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 5.37 lbs
 - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
 - 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	91	D4092	SHEET 4 OF 6
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D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

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2011-09-22
JWW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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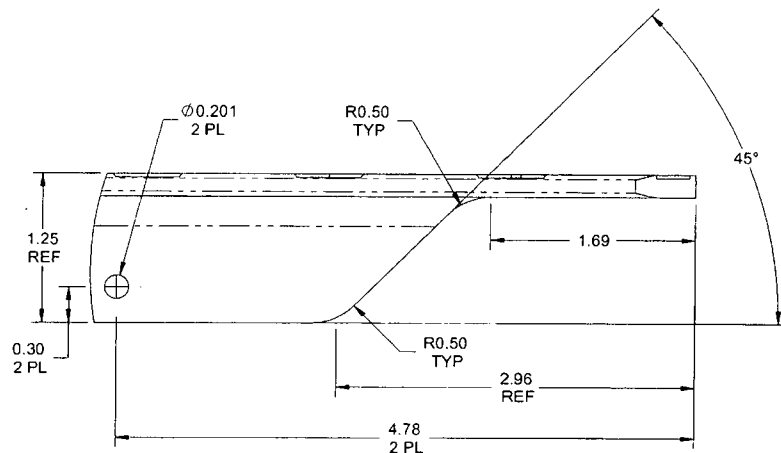
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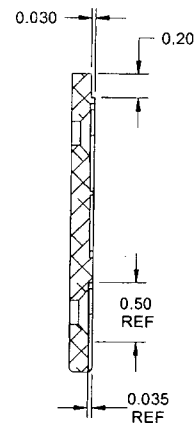
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B

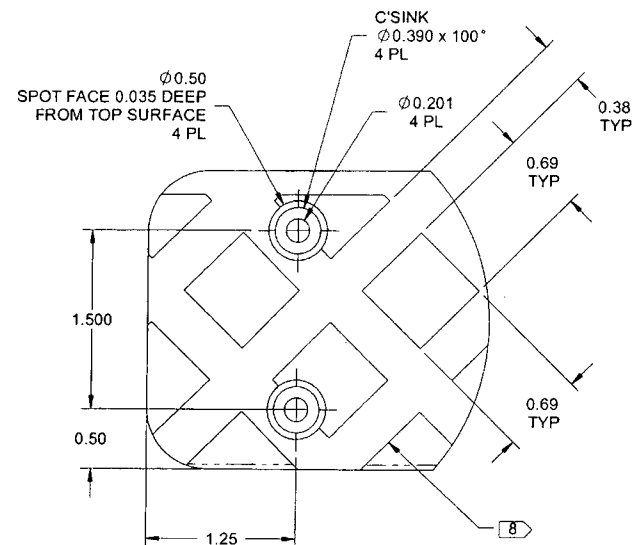
A



DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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2011-09-22
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DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>1/20</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>2/1</i>	D4092	SHEET 6 OF 6
APPROVED	<i>1/20</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1